

Work Order ID 148526

Tuesday, July 05, 2016 10:55:06 AM

148526

Page 1

Item ID: D206-667-207

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4

Start Date: 7/5/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/8/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: TOUCH UP/RETURN TO STOCK

Approvals: Process Plan: [Signature] Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-667	D								DAS 21 9-89 MAR 10 2017
100	Document Control	0.00							
100	DOCUMENT CONTROL								DAS 28 9-89
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D206-667-207 chg 002								MAR 13 2017
200	SprayPaint	0.00							
200									DAS 41 9-89
SprayPaint	Memo	0.21							
Spray Painting	PULL FROM TEST FIT: 1 X D206-667-207 B96272								16-7-13
	TOUCH UP A/R								

DAS DART AEROSPACE		1270 ABERDEEN ST. HAWKESBURY ON, CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartaero.com	
PATENT	N/A	CHG	CHG002
P/N	D206-667-207	STC	SH01-5
DESC	Crosstube Mid Aft	STC	SR01304NY
LOT	B96272	STC	
MODEL	Bell 206L/L1/L3/L4	STC	
TC APPROVAL # 09-89		MADE IN CANADA D2729-4	

Work Order ID 148526

Tuesday, July 05, 2016 10:55:06 AM

148526

Page 2

Item ID: D206-667-207 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4
Start Date: 7/5/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: TOUCH UP/RETURN TO STOCK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Wrap in plastic bag to protect from scratches								
	***VERIFY BY <u>EP</u> BATCH # TO MATCH W/O								
	***VERIFY BY <u>EP</u> PART # TO MATCH								
	W/O <u>148526</u>								
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging	ADD TO KIT:								
	4 X AN5-34A								
	4 X MS21042L5								
	8 X NAS1149C0563J								

DAS
27
9-89
MAR 13 2017

Work Order ID 148526

Tuesday, July 05, 2016 10:55:06 AM

148526

Page 3

Item ID: D206-667-207 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4
Start Date: 7/5/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: TOUCH UP/RETURN TO STOCK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 *260* QC Quality Control	QC4- 100% Inspect kits for completeness Memo ***VERIFY BY <u>148526</u> DAS 28 9-89 BATCH # TO MATCH W/O ***VERIFY BY <u>148526</u> DAS 28 9-89 PART # TO MATCH W/O <u>148526</u> DAS 28 9-89	0.00 0.00							DAS 28 9-89 MAR 13 2017
270 *270* Packaging Packaging Packaging	Packaging Memo RE-PACKAGE USING NEW B/N NEW LABELS REQUIRED Identify and pack for shipping as per PPP D206-667-207 Location : FG097	0.00 0.00							DAS 27 9-89 MAR 13 2017
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							DAS 21 9-89 MAR 13 2017

DAS 21 9-89

MAR 13 2017

Picklist Print

Tuesday, July 05, 2016 10:55:06 AM

Page 1

Work Order ID: 148526

148526

Parent Item: D206-667-207

D206-667-207

Parent Item Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4

Start Date: 7/5/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.09.11 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-34A

Purchased

No

Each

61.0000

4

AN5-34A

Bolt

Location

Loc Qty

Loc Code

over004

50

m133577

50

ST336

11

m128634

2

m133363

4

m134370

5

MS21042L5

Purchased

No

Each

501.0000

4

MS21042L5

Nut

Location

Loc Qty

Loc Code

GA

83

m127813

83

OVER007

250

m134509

100

m134955

150

ST303

168

m134055

6

m134762

62

m135058

100

m135577 X4

DAS
27
9-89

X4

m136450 X3
m136866 X1

DAS
27
9-89

DAS
28
9-89

DAS
28
9-89

Picklist Print

Tuesday, July 05, 2016 10:55:06 AM

Page 2

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148526

Parent Item: D206-667-207

D206-667-207

Parent Item Name: Aft Crosstube - Mid Height 206L / L1 / L3 / L4

Start Date: 7/5/2016

Required Date: 7/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

Each

1,425.000

8

NAS1149D0563.J

m136295 X8

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

211

m125807

2

m133769

209

ST263

1115

m134497

315

m135058

800

ST269

99

m128257

99

DAS
27
9-89

5.2 MID-HEIGHT CROSSTUBES

Item	Qty -107	Qty -207	Part Number	Description
	X		D206-667-107	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID FWD
		X	D206-667-207	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 MID AFT
7	1		D206-667-147	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID FWD
8		1	D206-667-247	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 MID AFT
10	*2		D2891-1	SUPPORT
11		*2	D2892-1	SUPPORT
13	*4		D3595-063-395	RUBBER CUSHION
14		*4	D3595-063-450	RUBBER CUSHION
16	*4		MS21920-20	CLAMP
17		*4	MS21920-22	CLAMP
19	4		AN5-32A	BOLT
20		4	AN5-34A	BOLT
21	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	NAS1149C0563J	WASHER (OR AN950JD516)
40	*2	*2	D2873-043	NUT PLATE
41	*2	*2	D2873-045	NUT PLATE
44	10		AN5-7A	BOLT
45		10	AN5-10A	BOLT
46	4		AN5-30A	BOLT
47		4	AN5-32A	BOLT
48	12		AN970-4	WASHER (OPTIONAL)
50	10*	10	NAS1149C0563J	WASHER (OR AN960JD516)

Ref x6 with highlighted

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-147/-247 ASSEMBLIES ABOVE